

Date: Tuesday, 3/18/2008 3:55:21 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	HELI ACCESS HANDLE WELDMENT ASS'Y, RH		
Job Number	38089			Part Number	D2480012		
Estimate Number	10947			Drawing Number	D2480 REV A1		
P.O. Number	:			Project Number	N/A		
This Issue	3/18/2008	S.O. No.	:	Drawing Revision	A1		
Prsht Rev.	NC			Material	:		
First Issue	/ /			Due Date	3/28/2008	Qty:	3
Previous Run	37460			Um:	Each		
Written By	:						
Checked & Approved By	3/18/08						
Comment	Est. C1 03.01.09 Added Powder Coat						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :			
1.0	D2478	Lower Arm			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Lower Arm Pick: Qty Part number Description Batch 1 D2478 Heli Access Handle B37462 → 3x ✓ dd					
2.0	D2479	Upper Arm			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Upper Arm Pick: Qty Part number Description Batch 1 D2479 Heli Access Handle B37463 → 3x ✓ dd					
3.0	D2481	Lower Mount Plate			
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) Lower Mount Plate Pick: Qty Part number Description Batch 2 D2481 Mounting Plate 23503 → 6x ✓ dd					
4.0	D2482	Upper Mount Plate			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Upper Mount Plate Pick: Qty Part number Description Batch 1 D2482 Mounting Plate B14648 → 3x ✓ dd 03/03/19 28					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS HANDLE WELDMENT ASS'Y, RH

Job Number: 38089

Part Number: D2480012

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Template DT 8333 (DT 2480 CJ)

LB 08/03/20 (3)

6.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08/03/20 (3)

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

LB 08/03/20 (3)

8.0 POWDER COATING

POWDER COATING



M107005

3X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

ML 08/03/20 (3)

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BL 08-03-24

(3)

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

PPA 37450

LC 08/03/20 (3)

(3)

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

DO 08/03/26

Job Completion



LC 08-03-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

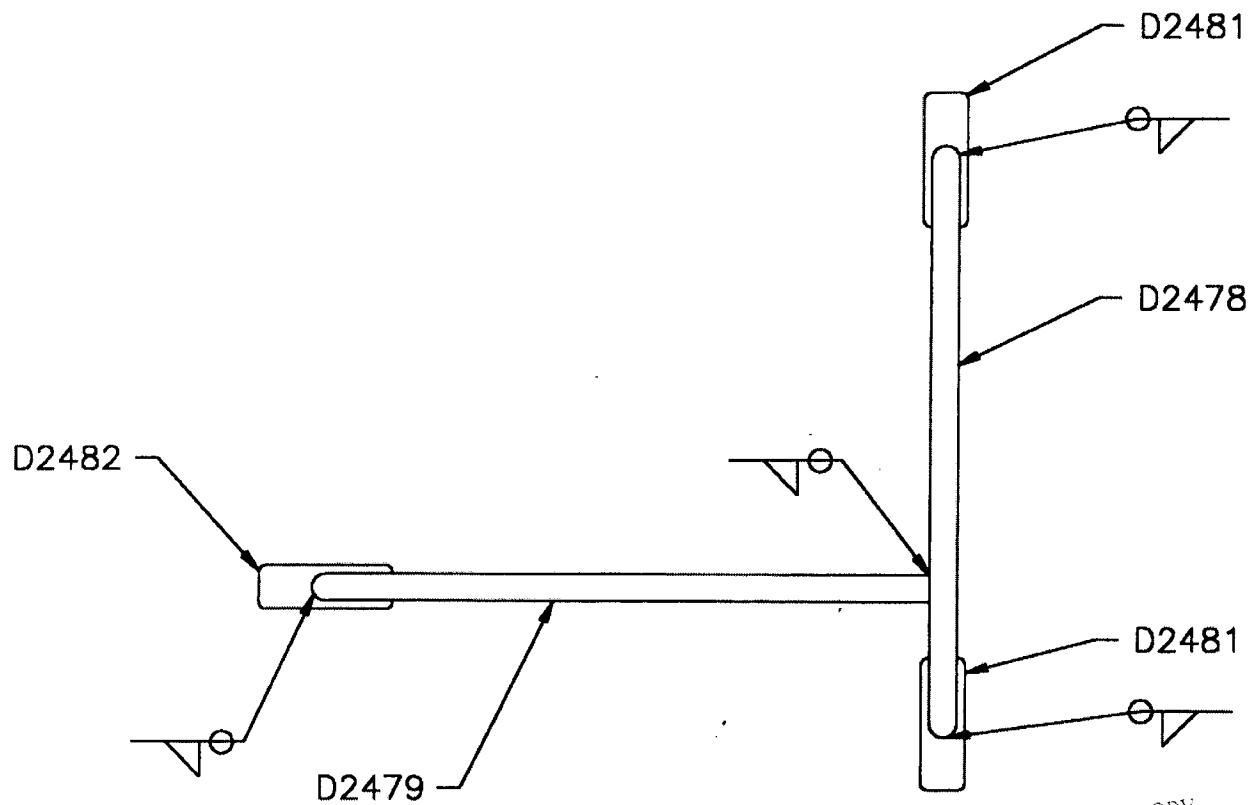
NOTE: Date & initial all entries

**DART**

DESIGN B WILLIAMS	DRAWN BY MIKE M	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>Br</i>	APPROVED <i>Br</i>	DRAWING NO. D2480	REV. A SHEET 1 OF 1
DATE 96:05:14		TITLE HANDLE WELDMENT ASSEMBLY	SCALE 6:1
A1 <del>10/05/06.23</del>		ADDED POWDER COAT	

**RELEASED**

96/10/02 DS



D2480-011 LH SHOWN  
D2480-012 RH OPPOSITE

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *38089*

NOTES:

1) WELD PER TEMPLATE DT 2480 WG PER QSI 004  
 2) POWDER COAT WHITE GLOSS (REF: 4.3.5.2) AS PER QSI 005